

Work Order ID 63211

Monday, October 25, 2010 12:34:19 PM

Page 1

Item ID: D212-725-1-077F

Accept

Setup Start

Revision ID:

Stop

Item Name: Gusset

Start Date: 10/25/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

B

0.00



Waterjet

0.00

FLOW CNC Waterjet

2024.040

Memo

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

10-10-27

9

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

121

Hand Finis

Acid + Alodine

122

QC3

130

Identify as per dwg & Stock Location: 385

0.00



Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(74)

4 BR 10-10-28.

CO 10/10/28 (4)

10/10/29 HJ

M/10-10-28
(4)

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Picklist Print

Monday, October 25, 2010 12:34:23 PM

Page 1

Work Order ID: 63211



Parent Item: D212-725-1-077F



Parent Item Name: Gusset

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

321.7400

0.1235

0.52



1810-10-27

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

84.2

114415

84.2

114415

(4)

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

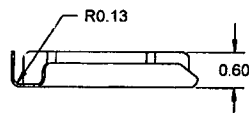
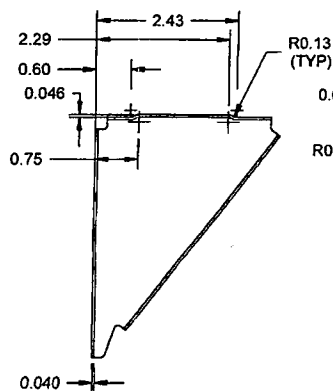
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

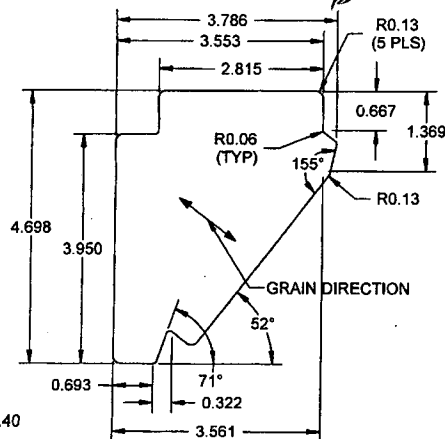
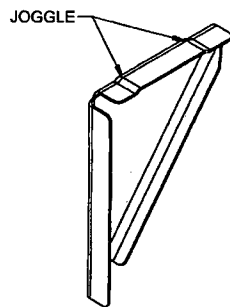
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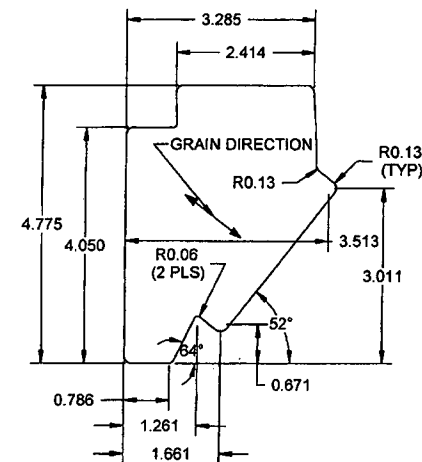
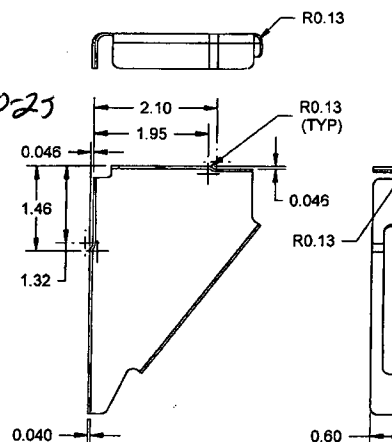
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43214
2110-1023



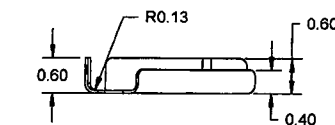
**D212-725-1-077 GUSSET (SHOWN)
D212-725-1-078 OPPOSITE
(MAKE FROM D212-725-1-077F FLAT PATTERN)**



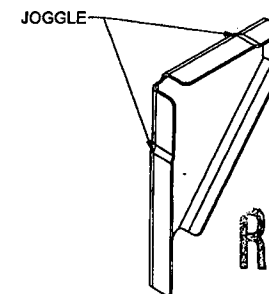
D212-725-1-077F FLAT PATTERN



D212-725-1-079F FLAT PATTERN



**D212-725-1-079 GUSSET (SHOWN)
D212-725-1-080 OPPOSITE
(MAKE FROM D212-725-1-079F FLAT PATTERN)**



RELEASED
2009-10-28

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	08.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1 REV. B
DATE 07.05.11	TITLE 212S DETAIL PARTS	SHEET 30 OF 44 SCALE 1:2
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